

5/22

DART AEROSPACE LTD	Work Order:	23158
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
14 05.06.02	Qty:	10 20 Kits
Dwg: D2521 Rev. H I		Page 1 of 1
Ref: K10015 Rev. A; DSK086-6 Rev. A		

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required	AP	05/05/09	20																																								
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately)	DH	05.06.03	20																																								
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00", thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: <u>M17726</u>	SD	05.06.04	10																																								
4	MV	Inspect material for defects or damage prior to machining	SD	05.06.04	10																																								
5	MV	Machine as per Folio FA222 and Dwg D2521 Identify as D2521	SD	05.06.04	10																																								
6	QC2	Inspect parts as they come off the CNC machine	SD	05.06.04	10																																								
7	MV	Deburr	SD	05.06.04	10																																								
8	MV	Form as per Dwg D2521 using bending Jig DT8328 N/A 05.05.20																																											
9	QC8 & 5	Second inspection	7m	05/06/08	10																																								
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>8</td><td>D2182B055</td><td>Rubber Cushion</td><td>B21872</td></tr><tr><td>16</td><td>D2274</td><td>Radius Block</td><td>B23174</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>B23158</td></tr><tr><td>16</td><td>D2529</td><td>Washer</td><td>B22504</td></tr><tr><td>8</td><td>D2947</td><td>Clamp</td><td>B21588</td></tr><tr><td>16</td><td>AN4-15A</td><td>Bolt</td><td>M14067</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M16941</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15924</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	B21872	16	D2274	Radius Block	B23174	2	D2521	Bearpaw	B23158	16	D2529	Washer	B22504	8	D2947	Clamp	B21588	16	AN4-15A	Bolt	M14067	16	AN960JD416	Washer	M16941	16	MS21042L4	Nut (or -4)	M15924	1	Paperwork package from Step 2			W	05/06/20	10
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1	Paperwork package from Step 2																																												
11	QC4	Inspect Kit for 100% Completeness on the W/O	CL	05/06/20	10																																								
12	PK	Identify and pack for shipping as per PPP K10015 REV.D	CL	05/06/20	10																																								
13	AC	Cost / part <u>6440</u>	AP	05/06/22	10																																								
14	DC	Close W/O <u>646.82</u> Inspect Level 2	AP	05.06.27	10																																								

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	

RELEASED
04.02.20

05/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	03158
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521	Rev: H	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.000	+/-0.030	1.003	/			
B	5.600	+/-0.030	5.596	/			
C	11.500	+/-0.030	11.500	/			
D	10.250	+/-0.010	10.250	/			
E	13.250	+/-0.010	13.250	/			
F	8.500	+/-0.010	8.500	/			
G	22.125	+/-0.030	22.125	/			
H	8.75	+/-0.010	8.750	/			
I	44.500	+/-0.030	44.500	/			
J	6.688	+/-0.030	6.688	/			
K	5.625	+/-0.030	5.624	/			
L	7.000	+/-0.030	7.000	/			
M	5.000	+/-0.010	5.000	/			
N	4.000	+/-0.030	3.996	/			
O	6.625	+/-0.030	6.625	/			
P	19.000	+/-0.030	19.000	/			
Q	0.31 x 45°	+/-0.030	.31 x 45°	/			
R	0.19 x 45°	+/-0.030	.19 x 45°	/			
S	0.50 x 45°	+/-0.030	.50 x 45°	/			
T	0.38 x 45°	+/-0.030	.38 x 45°	/			
U	0.063 x 45°	+0.030/-0.010	.070 x 45°	/			
V	Ø0.260	+0.005/-0.000	Ø.260	/			
W	Ø0.93	+/-0.030	.929	/			
X	0.30	+0.030/-0.010	.301	/			
Y	0.375	+/-0.010	.371	/			
Z	0.750	+/-0.030	.765	/			
AA	0.250	+/-0.010	.260	/			
AB	4.000	+/-0.030	4.000	/			
AC	6.625	+/-0.030	6.625	/			
AD	0.950	+0.030/-0.010	.957	/			
AE	0.375	+/-0.010	.377	/			
AF	3.399	+/-0.030	3.399	/			
AG	6.625	+/-0.030	6.625	/			

Measured by:	SP	Audited by:	PC	Prototype Approval:	N/A
Date:	05.06.04	Date:	05.06.06	Date:	N/A

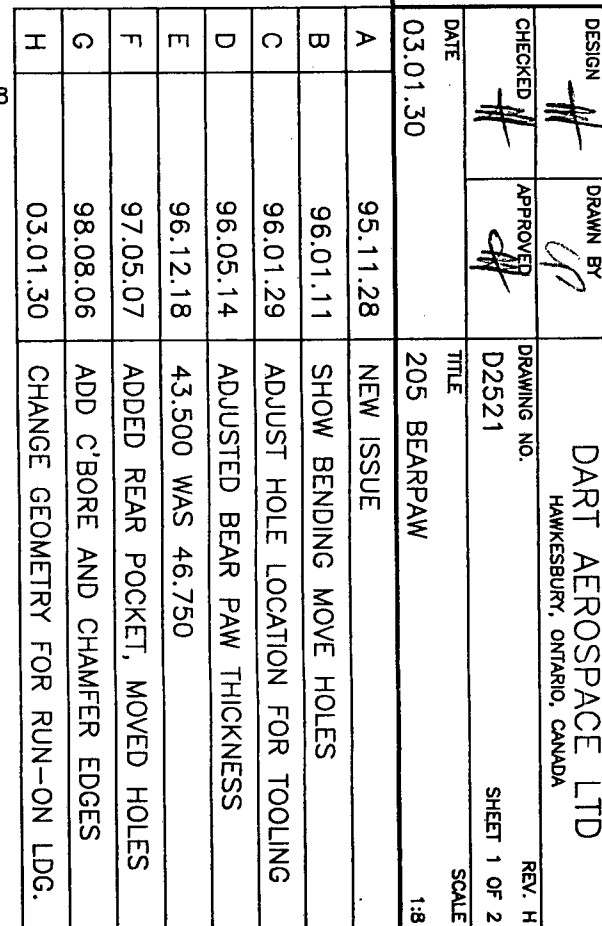
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O K10015	KJ/RF

RELEASED

04.01.15



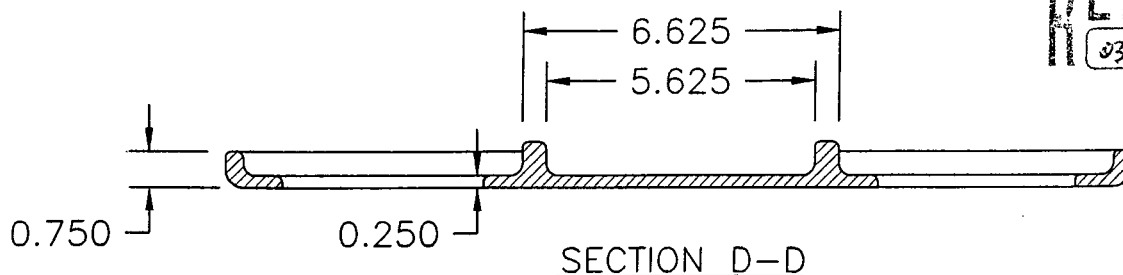
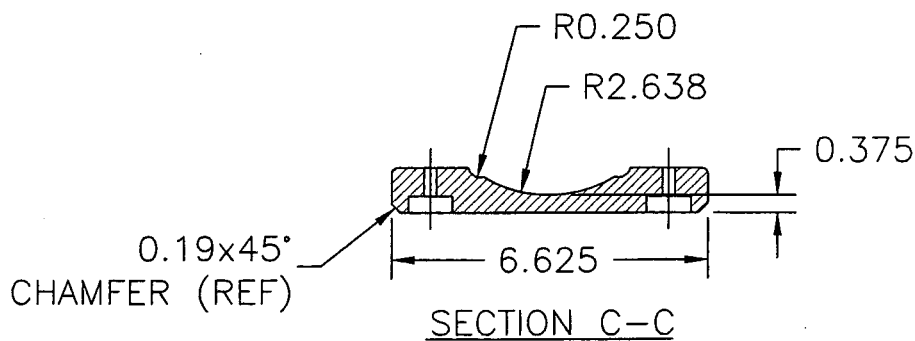
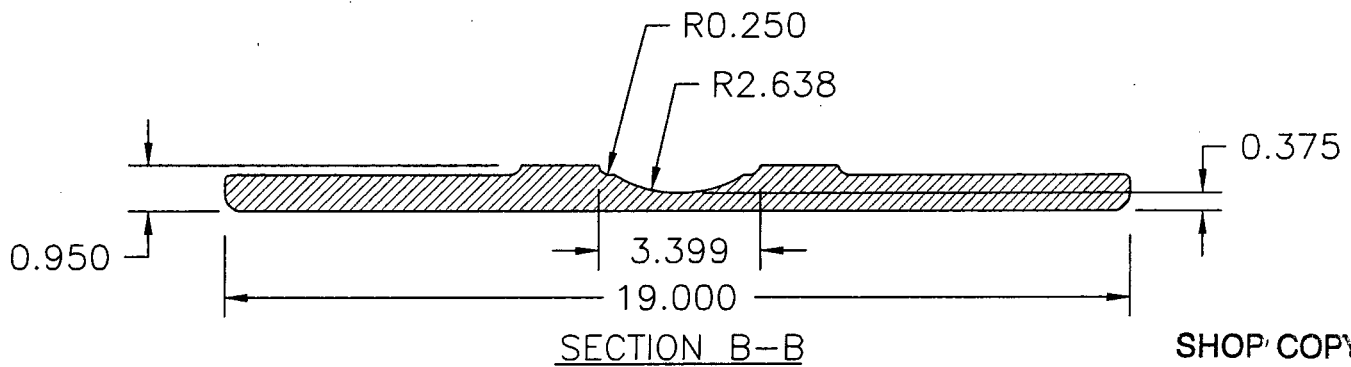
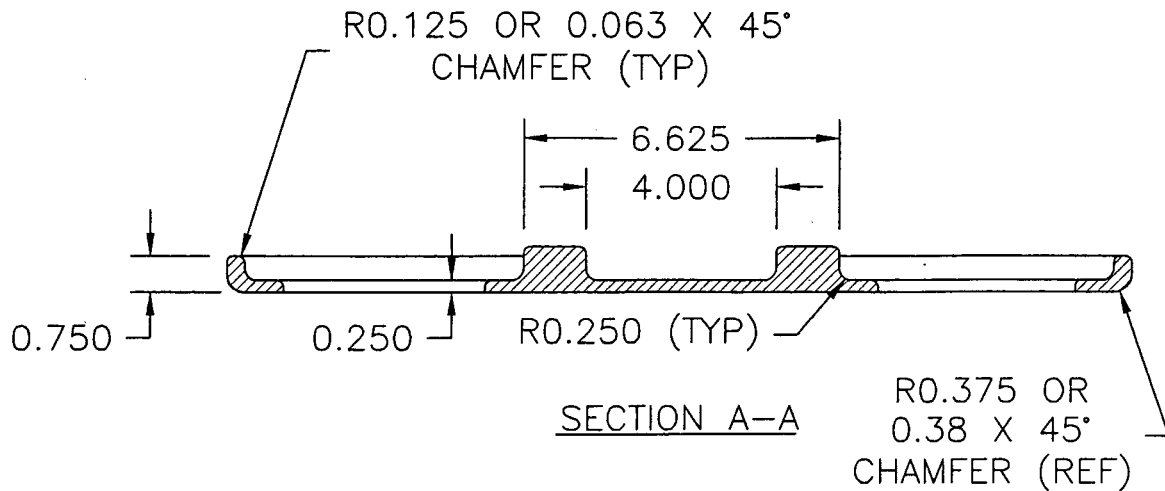
03.05.12 ~~47~~



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2521	REV. H SHEET 2 OF 2
DATE 03.01.30		TITLE 205 BEARPAW	SCALE 1:4



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO PRESENT
WITHOUT NOTICE
WORK ORDER
NO. 23158

RELEASED
03.05.12 *[Signature]*

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2005
09:55 am

Work Order No : 0023158
Project Name : K10015
Project For : WK522
Work Order Type : Main
Main WO Number :
House Part Number : *K10015
Description : Bearpaw Kit
Manufactured : Yes
Amount Req'd : 2070
Amount Done : 0
Start Date : 05-04-05
Est Finish Date : 05-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00